

Work Order ID 132304

132304

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Wednesday, May 06, 2015 1:50:57 PM

Item ID: D044-662-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: R44 Bearpaws
 Start Date: 5/6/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/8/2015 Req'd Qty: 1.00 *1* Customer:
 Reference: REWORK PER ECN 15-549

Approvals: Process Plan: MC Date: 15-5-6 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D044-662	E

150

0.00

150

Packaging

Packaging

Memo

0.00

PULL FROM STOCK D044-662-011 X 1 B130314

REWORK PER ECN15-549

NOW @ CHG 004

REMOVE AND BRING TO GA TO SCRAP: ✓ B121712
 D3556-1 X 4 REV B

REMOVE AND RETURN TO STOCK UNDER ORIGINAL BATCH
 NUMBER: B121712
 D2182B X 4 B128976 ✓ B123976

ADD TO KIT:

D3556-1 REV C X 4 B 131429

D453-1 REV B X 4 B 131442

ID AND STOCK UNDER NEW BATCH NUMBER AND NEW CHANGE 004

27
 15/05/19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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160	QC4- 100% Inspect kits for completeness	0.00							MAY 19 2015
160									
QC	Memo	0.00							
Quality Control									
	PK FG 014	MAY 19 2015							
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

ME
15-5-14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Wednesday, May 06, 2015 1:50:57 PM

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Work Order ID: 132304

132304

Parent Item: D044-662-011

D044-662-011

Parent Item Name: R44 Bearpaws

Start Date: 5/6/2015

Required Date: 5/8/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C04.02.19 Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D044-662-011

Manufactured

No

Each

0.0000

1

D044-662-011

R44 Bearpaws

D2182B

Manufactured

No

f

548.7680

-4

D2182B

Rubber Cushion - Black (\$Per Foot)

**

1 x 130314 mcf 15-5-6.

**

Location

Loc Qty

Loc Code

ST411

198.768

115189

21.5

128976

177.268

st640

350

130427

350

mcf 15-5-6.

D3556-1

Manufactured

No

Each

40.0000

4

D3556-1

Clamp For R44 Bearpaw

DAS
6
9-89

**

Location

Loc Qty

Loc Code

ST542

40

131429

40

Each

62.0000

4

D4953-1

Manufactured

No

D4953-1

Cushion

DAS
6
9-89

**

Location

Loc Qty

Loc Code

ST545

62

131442

62

DAS
27
9-89

DAS
27
9-89

4 x 15/05/19

4 x 15/05/20

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List Lots

Page 1 of 1

Wednesday, May 06, 2015 12:56:40 PM

Criteria : Item ID: d044-662-011 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D044-662-011 R44 Bearpaws	Main Warehouse FG013	130314	3/23/2015	1.0000	QC21	CHG003	
Total:				1.0000			

#132304

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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OTHER : ☐					

Wednesday, March 04, 2015 4:16:27 PM

Page 1

130314

D044-662-011

Required Date: 3/13/2015

Required Qty: 4.00

Comments: IPP Rev:C04.02.19Added tolerance and ref to DSK086-12 to Step 3KJ/JLM
IPP Rev:D As per ECN 932 & 862 06-07-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3075-1 *D3075-1* Bearpaw(Foot Print Only)		Manufactured	No			110	Each	0.0000	2	8			DAS 46 9-89
D2182B *D2182B* Seal(\$Per Foot)		Manufactured	No			110	f	327.4680	0.93	4		MAR 09 2015	DAS 46 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST411		327.468							
				115189		21.5							
				128976		305.968							
4 X 4.5" D2529 *D2529* Washer		Manufactured	No			110	Each	535.0000	8	32			DAS 27 9-89 MAR 09 2015
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST007		535							
				127909		35							
				128950		500							
D3556-1 *D3556-1* Clamp For R44 Bearpaw		Manufactured	No			110	Each	68.0000	4	16			DAS 46 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST542		68							
				114426		40							
				121712		28							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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